



# CROMAX® NS3310™, NS3340™, NS3370™ PRIMER SEALER



## GENERAL

### DESCRIPTION

A National Rule VOC compliant, three-component urethane primer sealer designed to provide excellent flow and leveling for spot, panel, and overall repairs. It delivers exceptional topcoat holdout and minimal overspray during application.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



## MIXING

### COMPONENTS

- NS3310™ Primer Sealer White – ValueShade® 1
- NS3340™ Primer Sealer Gray – ValueShade® 4
- NS3370™ Primer Sealer Dark Gray – ValueShade® 7
- XK305™ Activator, Medium (75°F, 24°C)
- XK306™ Activator, Slow (85°F, 26°C)
- XK307™ Activator, Very Slow (95°F, 35°C)
- NS3385™ Primer Sealer Additive

### MIX RATIO

Combine the components by volume (4:1:1) or by weight (see ValueShade® section below). Mix thoroughly.

Component	Volume
NS33xx Primer Sealer	4
XK30x Activator	1
NS3385 Primer Sealer Additive	1

- Shake the sealer on a mechanical shaker before first usage. To maintain thorough agitation, place sealer on a mixing machine.
- It is critical to use the full amount of NS3385 Primer Sealer Additive to ensure product performance.

### VALUESHADE® INSTRUCTIONS FOR USE

Use VS1, VS4 and VS7 as packaged or mix to create VS2, VS3, VS5, or VS6 per below. After creating the desired ValueShade, agitate thoroughly, activate and reduce.

ValueShade	Mix	Undercoat	Ratio
VS1 (White)	--	NS3310	--
VS2	VS1:VS4	NS3310 : NS3340	2:1
VS3	VS1:VS4	NS3310 : NS3340	1:2
VS4 (Med Gray)	--	NS3340	--
VS5	VS4:VS7	NS3340 : NS3370	2:1
VS6	VS4:VS7	NS3340 : NS3370	1:2
VS7 (Dark Gray)	--	NS3370	--

After creating the desired ValueShade, combine the components by volume (4:1:1) or by weight (cumulative grams). Mix thoroughly prior to activation.



ValueShade 1 Component	Mix size in fluid ounces		
	6 oz	14 oz	28 oz
NS3310	157g	364g	731g
XK305	188g	441g	878g
NS3385	219g	511g	1020g

ValueShade 2 Component	Mix size in fluid ounces		
	6 oz	14 oz	28 oz
NS3310	104g	119g	487g
NS3340	155g	357g	725g
XK305	187g	434g	872g
NS3385	217g	504g	1014g

ValueShade 3 Component	Mix size in fluid ounces		
	6 oz	14 oz	28 oz
NS3310	52g	119g	244g
NS3340	154g	364g	720g
XK305	186g	372g	867g
NS3385	216g	432g	1009g

ValueShade 4 Component	Mix size in fluid ounces		
	6 oz	14 oz	28 oz
NS3340	153g	357g	714g
XK305	185g	434g	861g
NS3385	215g	504g	1003g



**ValueShade 5  
Component**

	6 oz	14 oz	28 oz
NS3340	102g	238g	476g
NS3370	152g	357g	710g
XK305	164g	427g	857g
NS3385	214g	497g	999g

**ValueShade 6  
Component**

	6 oz	14 oz	28 oz
NS3340	51g	119g	238g
NS3370	151g	350g	705g
XK305	183g	427g	852g
NS3385	213g	497g	994g

**ValueShade 7  
Component**

Mix size in fluid ounces

	6 oz	14 oz	28 oz
NS3370	150g	350g	700g
XK305	182g	427g	848g
NS3385	212g	497g	989g

**VISCOSITY**

17-19 seconds in a Zahn #2 cup

**POT LIFE**

45 minutes at 75°F (24°C)

**ADDITIVES**

Accelerator:

Not required

Fish Eye Eliminator:

Not required

Retarder:

Add up to ½ oz. Plas-Stick® 2350S™ Flex Additive per RTS quart

Flex Additive:

Add ½ oz. Plas-Stick 2350S Flex Additive per RTS quart

**TINTING**

Not recommended



**APPLICATION**

**SUBSTRATES**

Properly sanded OEM finishes and OEM replacement parts  
 Metal Pretreatment Wipes 495™  
 Direct to 420™ Etch Primer  
 Polyolefin Adhesion Promoter 310A™  
 Direct to 300™ Adhesion Promoter  
 Properly sanded Cromax Premier LE3130S™ UV Primer-Surfacer  
 Properly sanded PS3301™ Primer Filler  
 Properly sanded 33430S™ or LE3540S™

**TOPCOATS**

Cromax XP™ Basecoat  
 Cromax EZ™ Basecoat  
 Cromax Pro™ Basecoat

**Tips for Success**

This urethane sealer is not intended for use direct to metal, except for minor styling line cut-throughs.

**SURFACE PREPARATION**

- Clean painted surface thoroughly with mild detergent and water.
- OEM replacement parts can be thoroughly cleaned with a gold scuff pad and surface cleaner.
- For substrates other than unprimed plastic or fiberglass, wipe surface with surface cleaner.
- For unprimed plastic and fiberglass, refer to the plastic repair procedure.
- Finish sand with P500 or P600. Refer to the basecoat recommendation.
- Remove sanding sludge with Axalta 200™ Surface Cleaner.

**GUN SETUPS\***

Gravity Feed	Fluid tip
HVLP	1.3 mm-1.4 mm
ATE, approved transfer efficiency	1.3 mm-1.4 mm

**SPRAY PRESSURE\***

HVLP	8-10 psi at the cap
ATE, approved transfer efficiency	Follow manufacturer's recommendation

\*The listed setups cover the usual range for most application equipment.

**APPLICATION**

Apply 1 medium-wet coat.

**EQUIPMENT CLEANING**

Clean spray equipment as soon as possible using either Axalta 105 or 107 Low VOC/Low HAPS equipment cleaner.



**DRY TIMES**

**AIR DRY**

Nib Sanding:	20 minutes
Topcoating:	20 minutes

**Tips for Success**

Cooler temperature or more coats will require longer flash times.  
 Dry Film Thickness: to 0.8 to 1.2 mil.



### RECOATIBILITY / RE-REPAIR

When recoating NS33xx series Sealers with itself or topcoating with Cromax XP, sanding is required if the sealer has been allowed to air dry more than 2 hours and no more than 1 hour when top coating with Cromax EZ Basecoat or Cromax Pro Basecoat.



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### PHYSICAL PROPERTIES

Theoretical Coverage:	552 sq. ft. per RTS gallon at 1 mil
Recommended Dry Film Thickness:	0.8 to 1.2 mil in 1 coat
Flash Point:	See SDS

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### VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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### SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:  
**1.855.6.AXALTA**  
**cromax.us**

In Canada:  
**1.800.668.6945**  
**cromax.ca**

